

Date: Thursday, 11/15/2007 1:27:19 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 35783	
Estimate Number : 12487	
P.O. Number :	Part Number : D35021
This Issue : 11/15/2007 S.O. No. :	Drawing Number : D3502 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 32205	Material :
Written By :	Due Date : 12/20/2007 Qty: 40 ²⁰ Um: Each
Checked & Approved By : <u>8/07/11/16</u>	
Comment : Est Rev:A New Issue 06-07-06 JLM	
Est Rev:B Add tooling hole 07-03-28	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X04000 6061-T6 Bar 1.0" x 4.0"



Comment: Qty.: 0.3035 f(s)/Unit Total : 12.1380 f(s)
 6061-T6 Bar 1.0" x 4.0"
 batch: M106348

J.L 08/03/10

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 3.475" long

J.L 08/03/10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: B

2-Deburr per dwg D3502

DIP 08/03/12

SF 08/03/12

PTO

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 08/03/12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/05/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3502-1 PAR #: N/A Fault Category: Prod / Machined parts NCR: Yes No DQA: Yes Date: 08/03/19
 QA: N/C Closed: Yes Date: 08/03/19

NCR: <u>35783</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/12	3.0	First parts was scrap because the operator who made the setup put the jig on the wrong side. R.C operator error.	08/03/12	Scrap as Defect Replace <u>Qty x1</u> B-M <u>106348</u>	8/F 09/03/13	08/03/13	08/03/14	08/03/13

NOTE: Date & initial all entries

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Drawing Name: SUPPORT

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Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill as per Dwg D3502.

Bo 08/03/14 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-L 08/03/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005

BR 08-03-18

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/03/18

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

105 8/3/18 SCD (40)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LD 08/03/19

Job Completion



mi 2008/3/18 (40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

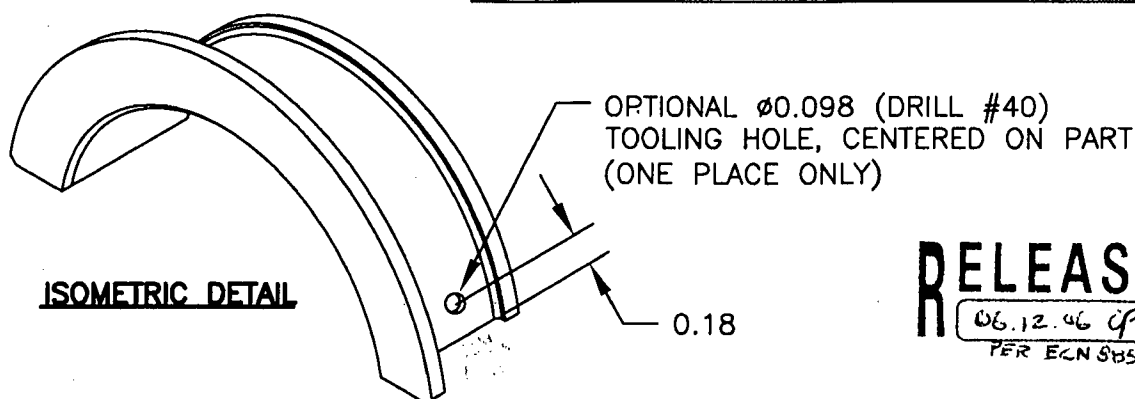
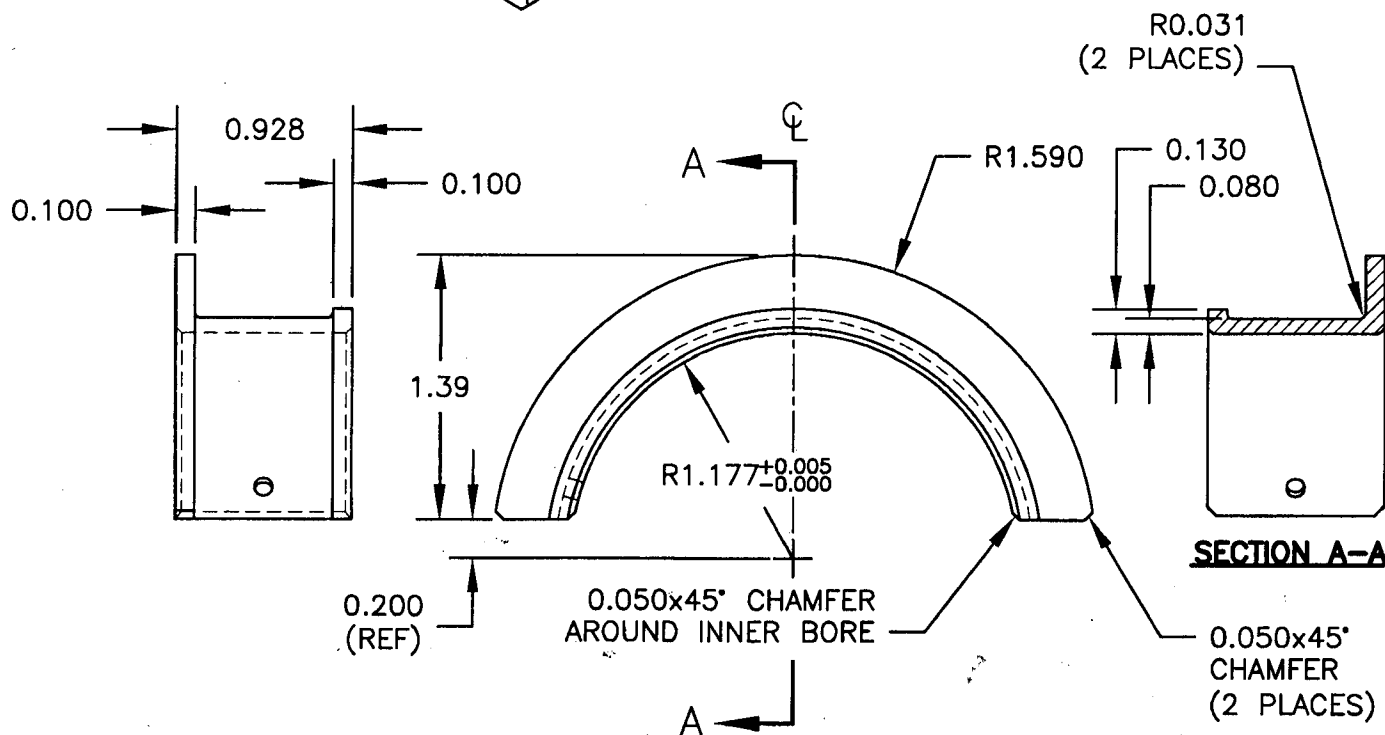
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ///	APPROVED ///	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	

**ISOMETRIC DETAIL****RELEASED**
06.12.06 qp
PER ECN 835**D3502-1 SUPPORT**

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35783

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